

shp Mar 16/05

Work Order ID 69573

Thursday, May 12, 2011 11:19:37 AM



Item ID: D3675-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Sliding Door Bracket

Start Date: 5/12/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3675	RevD								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3675

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary.

B11-5-12



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-5-12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/15/13



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69573

Thursday, May 12, 2011 11:19:37 AM



Page 2

Item ID: D3675-5

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Setup Start



Revision ID:

Item Name: Sliding Door Bracket

Stop



Start Date: 5/12/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3675 use DT9723

0.00

0.00

SP 11/05/13

6

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/11/05/13

6

5

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

10:50
320 OF
11:20

6x Ø m-f 11/05/13

11/11/5128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69573

Thursday, May 12, 2011 11:19:37 AM

Page 3

Item ID: D3675-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Sliding Door Bracket

Start Date: 5/12/2011 Start Qty: 3.00

Required Date: 5/16/2011 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location **26B**

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

[Handwritten signature]
4/15/13 60

[Handwritten signature]
4/15/13 60

[Handwritten signature]
11/5/16
ME
11-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 11:19:34 AM

Page 1

Work Order ID: 69573

Parent Item: D3675-5

Parent Item Name: Sliding Door Bracket



Start Date: 5/12/2011

Required Date: 5/16/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 11.01.11 new issue DD verified by:EC IPP Rev C
11.03.31 ECN 11-531 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	86.7000	0.4092	1.292211			

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

86.7

116623

0.2

117550

86.5

117550

6

1311-5-12

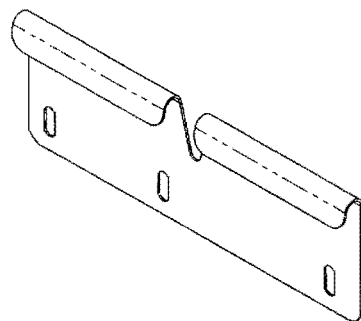
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

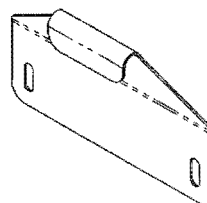
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

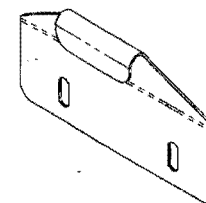
NOTE: Date & initial all entries



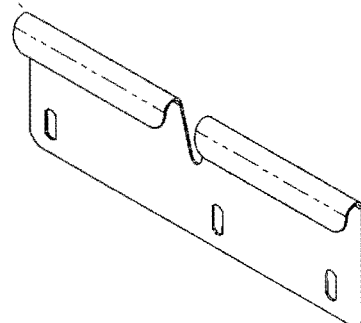
D3675-5 SLIDING DOOR BRACKET



D3675-1 SLIDING DOOR BRACKET



D3675-3 SLIDING DOOR BRACKET
(HINGE PANEL MOD)



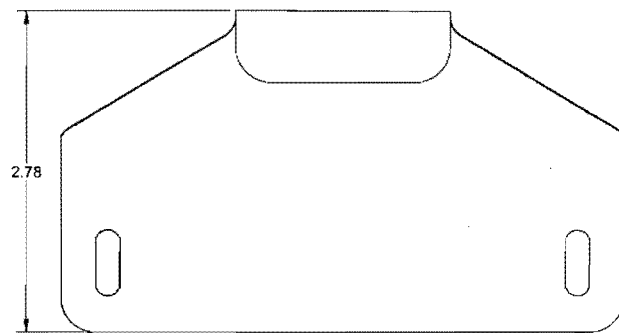
D3675-6 SLIDING DOOR BRACKET

RELEASED
R 2011-03-31

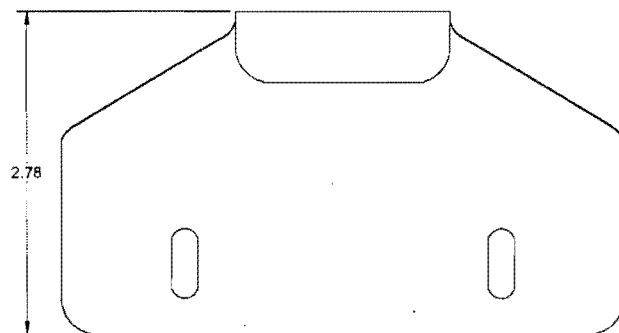
W/O 69573

D	RE-DESIGNED D3675-5/-6/-6F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF: PAR11-79	MB	11.03.21
C	ADD -5/-5F/-6 BRACKET	MB	10.12.17
B	ADD -3 FOR HINGE PANEL MOD.	AJS	08.11.03
A	NEW ISSUE	AJS	08.03.27
REV	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	AJS		
MFG. APPR.	AJS		
APPROVED	AJS		
DE APPR.	AJS		
DATE	11.03.21		

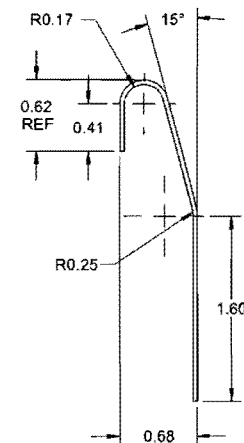
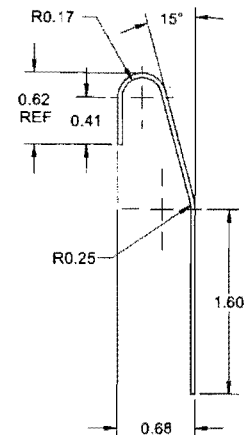
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3675	REV. D
TITLE SLIDING DOOR BRACKET (COMPOSITE DOOR)	SHEET 1 OF 6
SCALE NTS	
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D3675-1 SLIDING DOOR BRACKET
(MAKE FROM D3675-1F)



D3675-3 SLIDING DOOR BRACKET
(MAKE FROM D3675-3F)
(HINGE PANEL MOD)



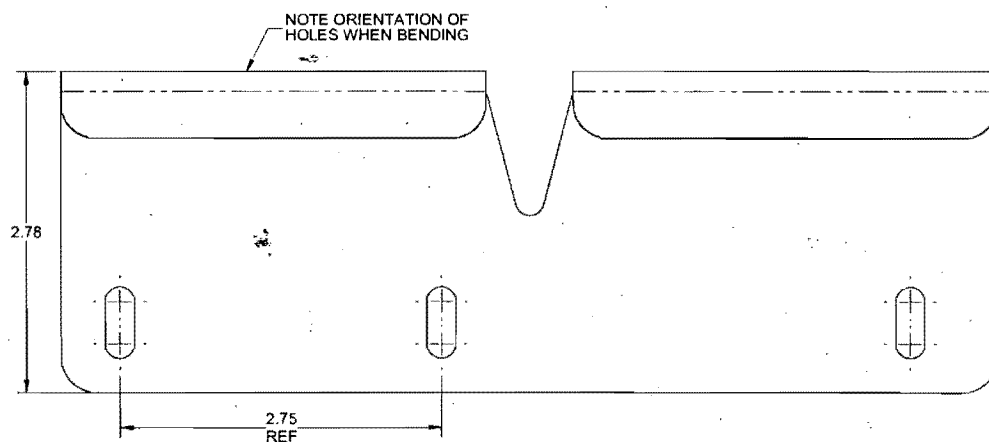
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2011-03-31
JH

NOTES:

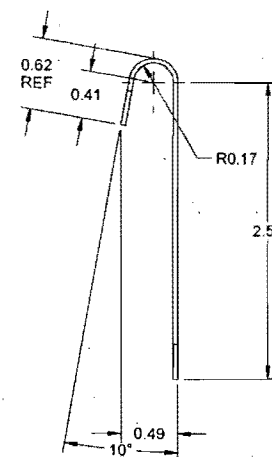
- 1) MATERIAL: SEE SHEET 5
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs EACH
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

64573

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	AJS	D3675	SHEET 2 OF 6
APPROVED	AJS	TITLE	SLIDING DOOR BRACKET
DE APPR.	AJS		(COMPOSITE DOOR)
DATE	11.03.21	SCALE	NTS
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D3675-5 SLIDING DOOR BRACKET
(MAKE FROM D3675-5F)



RELEASED
2011-03-30
AM

NOTES:

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-5" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs EACH
- 8) THE D3675-5 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-3 BRACKET.

69573

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	N	D3675	SHEET 3 OF 6
APPROVED	AS	TITLE	SLIDING DOOR BRACKET
DE APPR.	AS	(COMPOSITE DOOR)	SCALE
DATE	11.03.21		NTS

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8 7 6 5 4 3 2 1

D

D

C

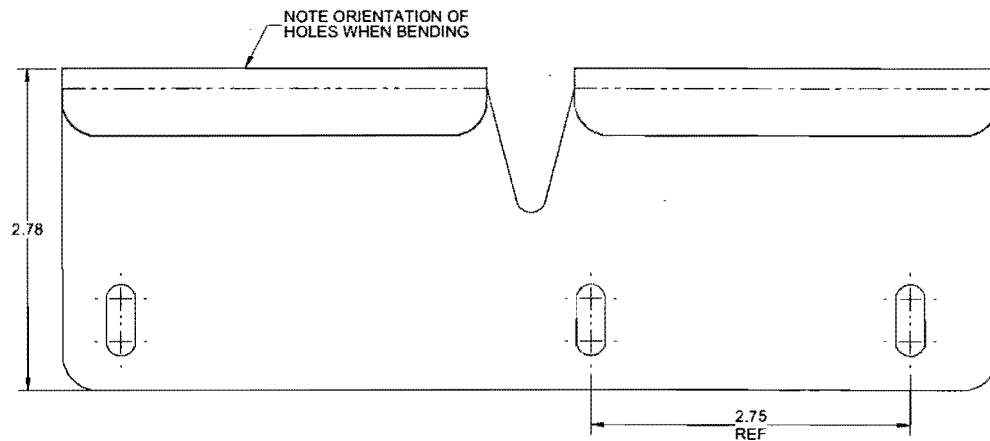
C

B

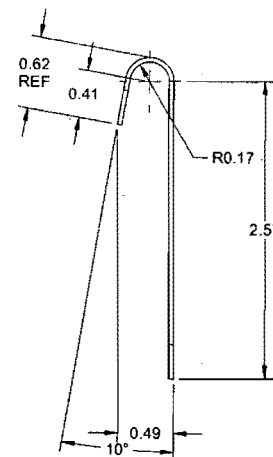
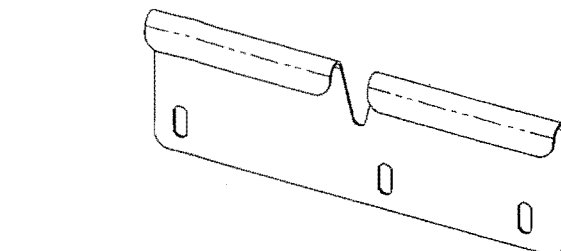
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A

A



D3675-6 SLIDING DOOR BRACKET
(MAKE FROM D3675-5F)



RELEASED
2011-03-31

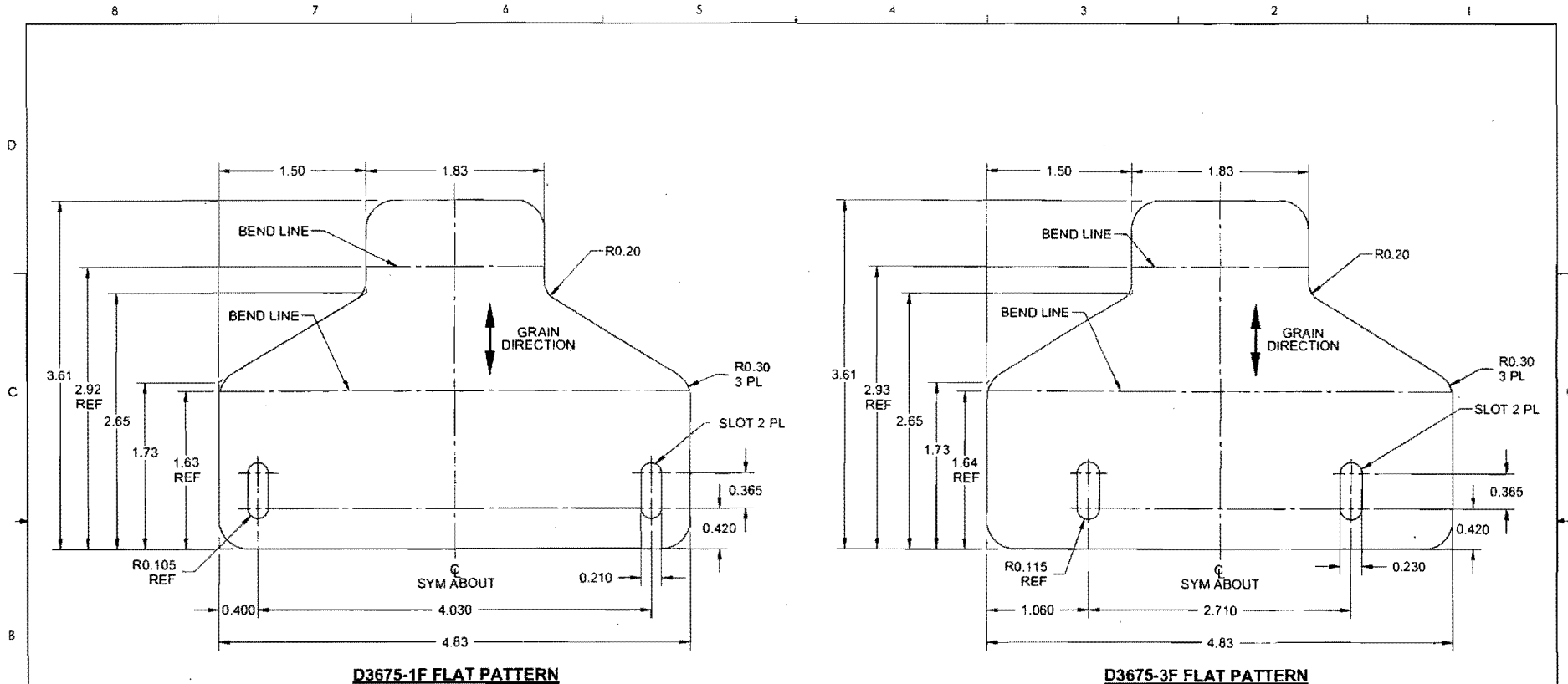
NOTES:

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-6" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs EACH
- 8) THE D3675-6 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-4 BRACKET.

69573

DESIGN	7.15	DART AEROSPACE LTD	
DRAWN	7.15	HAWKESBURY, ONTARIO, CANADA	
CHECKED	7.15	DRAWING NO. D3675	REV. D
MFG. APPR.	N	SHEET 4 OF 6	
APPROVED	7.15	TITLE SLIDING DOOR BRACKET (COMPOSITE DOOR)	SCALE NTS
DE APPR.	7.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



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2011-03-31

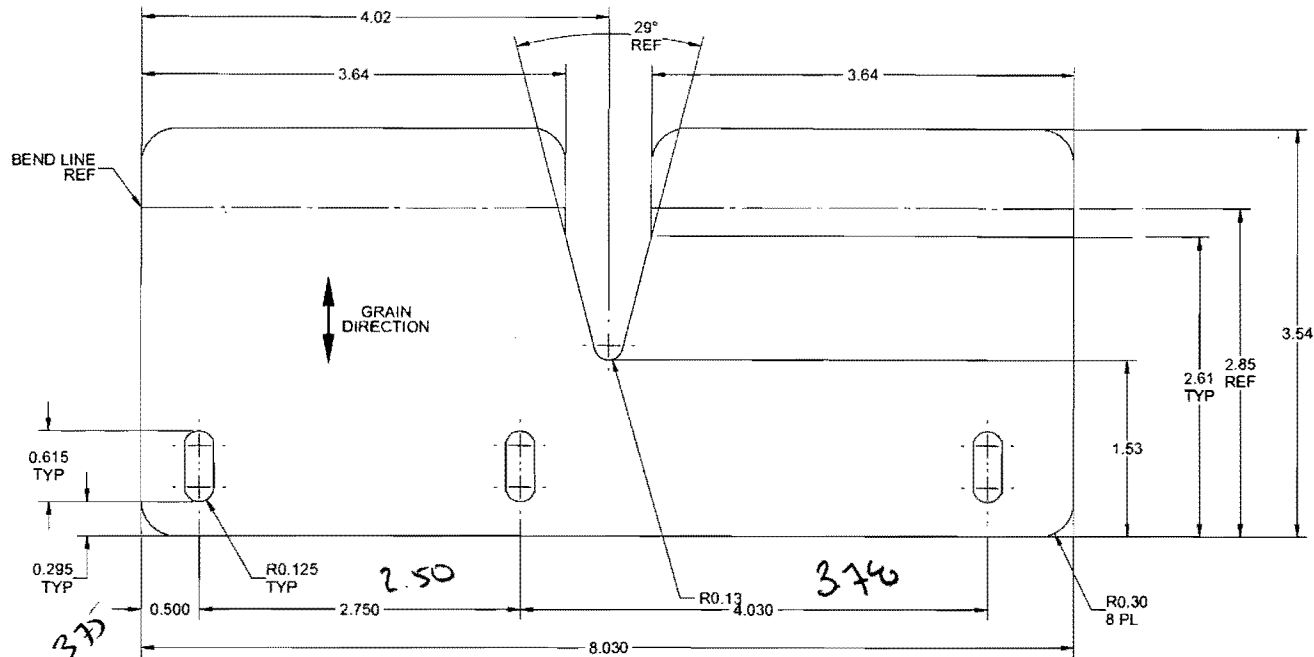
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs EACH

69573

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D3675	SHEET 5 OF 6
APPROVED	AS	TITLE SLIDING DOOR BRACKET	
DE APPR.	AS	(COMPOSITE DOOR)	
DATE	11.03.21	SCALE	
		NTS	

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D3675-5F FLAT PATTERN

RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

69573

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	AJS	D3675	SHEET 6 OF 6
APPROVED	AJS	TITLE	SLIDING DOOR BRACKET
DE APPR.	AJS	(COMPOSITE DOOR)	SCALE
DATE	11.03.21	NTS	

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